

split
Work Order ID 64906 -1

Wednesday, December 22, 2010 2:57:21 PM

Page 1

Item ID: D350-591-311

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date: 10/22/22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

0.00

CHG002

110

0.00



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 11102436

3-Grind End Plate flush

1115928

0.00

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-591-311	CHG	CHG001		
DESC.	704A 41 640 012	STC	SH92-6		
LOT	B64906	STC	SH967NE		
MODEL	AS350/355	STC			
MADE IN CANADA				D2729-1	

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Page 2

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Required Date: 1/24/2011 Req'd Qty: 5.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



Cust Item ID:

Customer:



5 0 BE 11/01/06

5 11/01/07

75 41

11/01/10

75 41

Work Order ID 64906

Wednesday, December 22, 2010 2:57:21 PM

Page 3

Item ID: D350-591-311

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Revision ID:

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Start Date: 12/22/2010 Start Qty: 5.00

Required Date: 1/24/2011 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.01.11

5

11.01.11

5

Work Order ID 64906

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Item ID: D350-591-311

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Setup Start

Revision ID:

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Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QS1004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

5 0 2E 11/10/12

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sulaluz

15 64

210

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

54H BL 11-a-12.

Work Order ID 64906



Page 5

Wednesday, December 22, 2010 2:57:21 PM

Item ID: D350-591-311

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115451

Memo

0.00

START TIME: 3:35

OVEN TEMPERATURE: 320

FINISH TIME: 4:05

56H BR 11-01-12

230



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M1157900

0.00

Memo

56H 20 11/01/13

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8/10/14

+5
LM

Work Order ID 64906



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Wednesday, December 22, 2010 2:57:21 PM

Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

11/13 SP (58)

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

Subalry

Subalry

XF
LH

H/LH

270



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD350-591-311
Location: 01

0.00

0.00

Per 0

11/14 SP (58)

rk Order ID 64906



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Wednesday, December 22, 2010 2:57:21 PM

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Stop



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Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/14

h 11.01.14

Print

Page 1

Tuesday, December 22, 2010 2:57:27 PM

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	5		11.03.364911	
Step D3067-1 		Manufactured	No			110	Each	116.0000	1	5		11.01.06	
End Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		116							
				60141		2							
				62664		6							
				63550		108							
D3219-1 		Manufactured	No			110	Each	113.0000	2	10		11.01.06	
Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		113							
				63551		113							
D3066-1 		Manufactured	No			180	Each	86.0000	2	10		11.01.11	
Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		86							
				63549		86							

11.03.03 364911

11.01.06

10
11.01.06

10
11.01.11

10

Picklist Print

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Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

2,351.000

16

80



11.01.11

Rivets

Location

Loc Qty

Loc Code

ST321

2351

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

20

D3065-041

Manufactured

No

180

Each

42.0000

1

5



11.01.11

Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

42

63324

2

63555

40

5

D3067-1

Manufactured

No

180

Each

116.0000

1

5



11.01.11

End Plate

Location

Loc Qty

Loc Code

WA

116

60141

2

62664

6

63550

108

5

Picklist Print

Page 3

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Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH



Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

250

Each

118.0000

2

10



Bolt



m116549 11/13/10

Location

Loc Qty

Loc Code

ST353

118

116191

100

116419

18

D3235-1

Manufactured

No

250

Each

61.0000

2

10



Mounting Lug



11/13/10

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041

Manufactured

No

250

Each

8.0000

1

5



Support Assembly



B63553 11/13/10

Location

Loc Qty

Loc Code

ST460

8

64731

8

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

30.0000

16

80



Washer



m116304 11/13/10 st

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

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Shop Packet Print

Page 3

Picklist Print

Wednesday, December 22, 2010 2:57:27 PM

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

4 20



Washer



11/14/10 11/1/10

Location

Loc Qty

Loc Code

ST
103694
107534
109287

34
18
12
4

250 Each

101.0000

2 10

AN5-36A

Purchased No



Bolt



11/1/10

Location

Loc Qty

Loc Code

ST341
114292
116191

101
1
100

250 Each

36.0000

2 10

D2618

Manufactured No



Bushing



11/1/10

Location

Loc Qty

Loc Code

ST019
63548

36
36

250 Each

94.0000

4 20

D2230-3

Manufactured No



Lug



11/1/10 (50)

Location

Loc Qty

Loc Code

ST476
55452
63312
64422

94
2
12
80

250 Each

94.0000

4 20

Picklist Print

Wednesday, December 22, 2010 2:57:27 PM

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

275.2930 1.2



11/11/358

Abraison Strip

Location

Loc Qty

Loc Code

ST403

275 2930421

56626

0.00004211

59920

59.293

63735

216

5x
5x

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

1,870.000 2



10
11/11/358

Nut

Location

Loc Qty

Loc Code

ST300

1870

114784

9

115835

957

116373

4

116391

900

10

AN4-13A

Purchased No

250 Each

274.0000 8



40
11/11/358

Bolt

Location

Loc Qty

Loc Code

ST357

274

116191

274

40

Picklist Print

Wednesday, December 22, 2010 2:57:27 PM

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

1,199.000

2

10

Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1173

115156

5

115594

500

116104

172

116105

496

MS21042L4

Purchased

No

250

Each

4,242.000

8

40

Nut

Location

Loc Qty

Loc Code

ST300

4242

1123143

2

115589

10

115621

730

116188

3500

AN960JD10

NAS1149D0363J Purchased

No

250

Each

8.0000

4

20

Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

B 63714

CH7001

Shop Packet Print

1 x DSI9410-011

Wednesday, December 22, 2010 2:57:27 PM

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

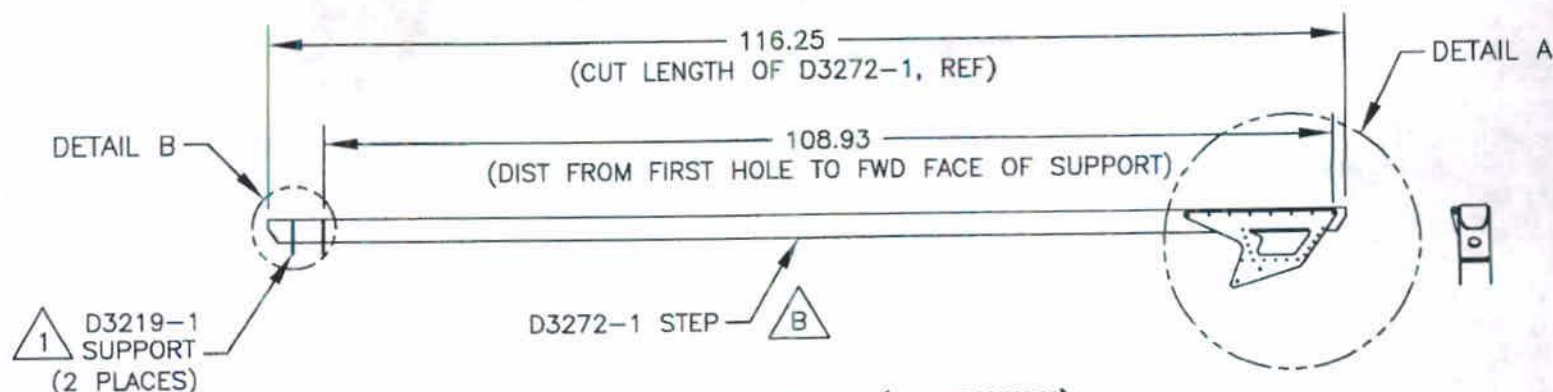
SHOP COPY
RETURN TO
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
ATTN: *10-1272*
WORK ORDER
NO. *44904*
BS 10-1272

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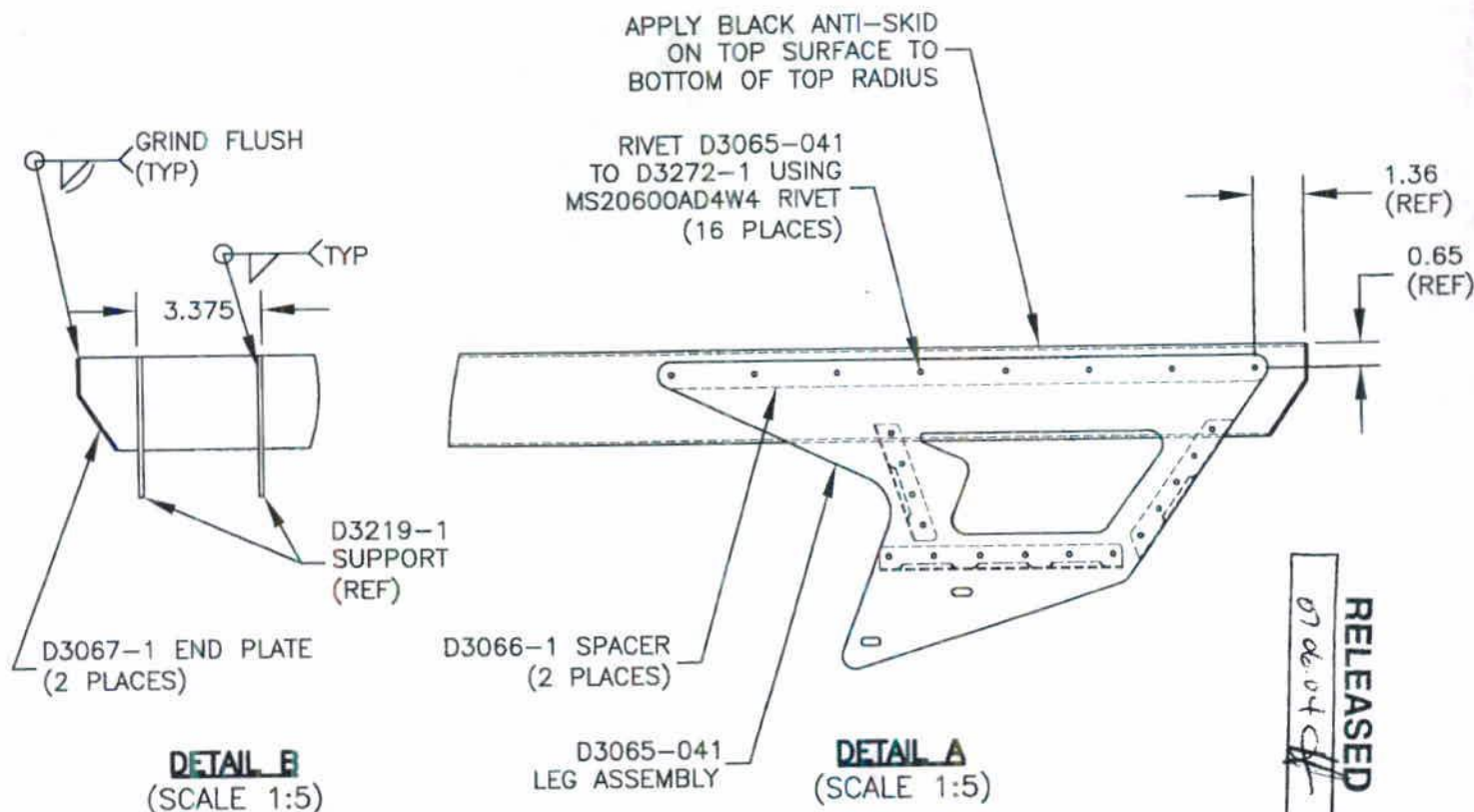
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	

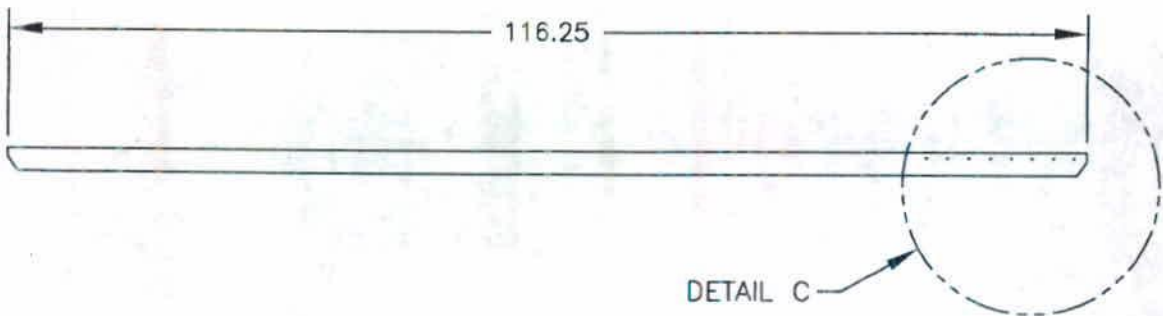


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



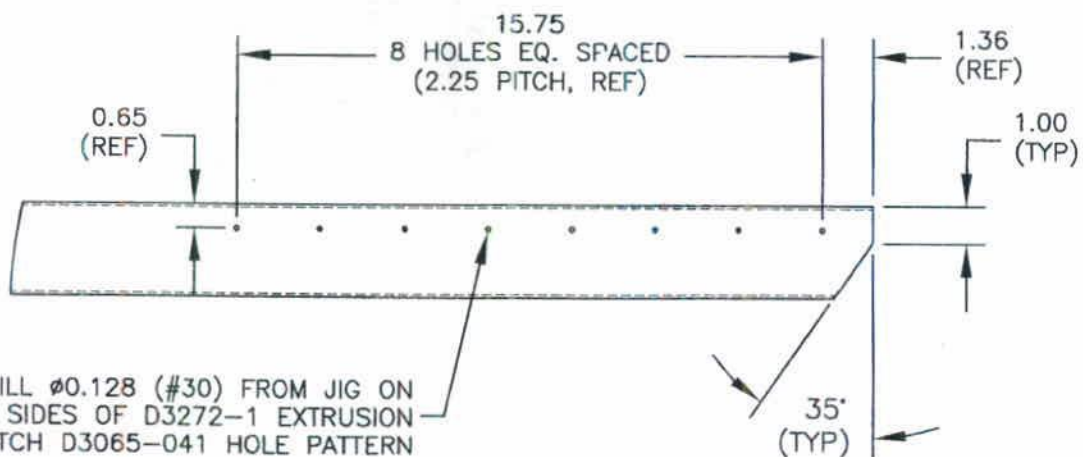
DART

DESIGN	q	DRAWN BY	JR	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	H	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 3
DATE	07.05.18	TITLE	D3272	STEP ASSEMBLY, HI LONG	SCALE 1:20



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

u1044904



DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.